

Date: Thursday, 8/30/2007 3:51:25 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 34368		
Estimate Number	: 10531		
P.O. Number	: <i>N/A</i>	Part Number	: D2572
This Issue	: 8/30/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2572 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 33041	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/21/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	8 Um: Each
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: *1531388*

*[Signature]* 02.10.25 8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No: *32* Double check by: \_\_\_\_\_

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove shap edges.

*[Signature]* 02/10/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

*[Signature]* 02/10/25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]* 07/10/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/18/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:51:25 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34368

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

FF 07/10/26 (8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/10/29 (8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BL 07-10-29

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS

BL

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 432

(8) 07/10/30 AS

BL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BL 07/10/30

Job Completion



W 07-10-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 34368
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.439	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.005	8.005	8.000	8.001		
F	0.490	0.510		.505	.506	.502	.505		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.506	.502	.505	.505		
J	1.174	1.184		1.179	1.179	1.179	1.180		
K	0.558	0.578		.571	.578	.571	.571		
L	1.174	1.184		1.179	1.179	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.122	.122	.124	.124		
Q	0.115	0.135		.123	.127	.135	.135		
R	0.240	0.260		.251	.251	.250	.250		
S	0.115	0.135		.125	.129	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.242	.239	.239		
W	0.115	0.135		.125	.125	.125	.124		
X	0.307	0.312		.312	.312	.311	.311		
Y	0.760	0.765		.763	.760	.760	.750		
Z	0.352	0.372		.366	.36	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>261 JF</i>
Date: <i>02/10/25</i>

Audited by: <i>J.F.</i>
Date: <i>07/10/20</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34368
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

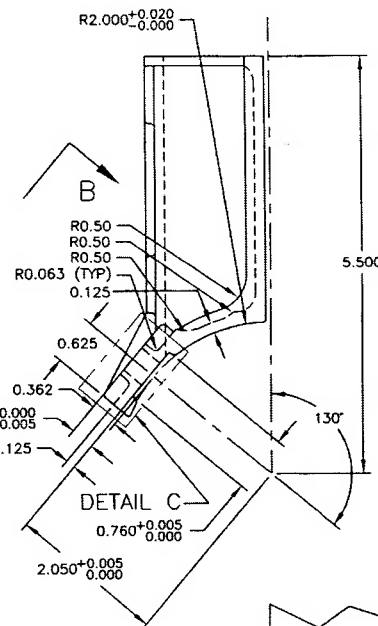
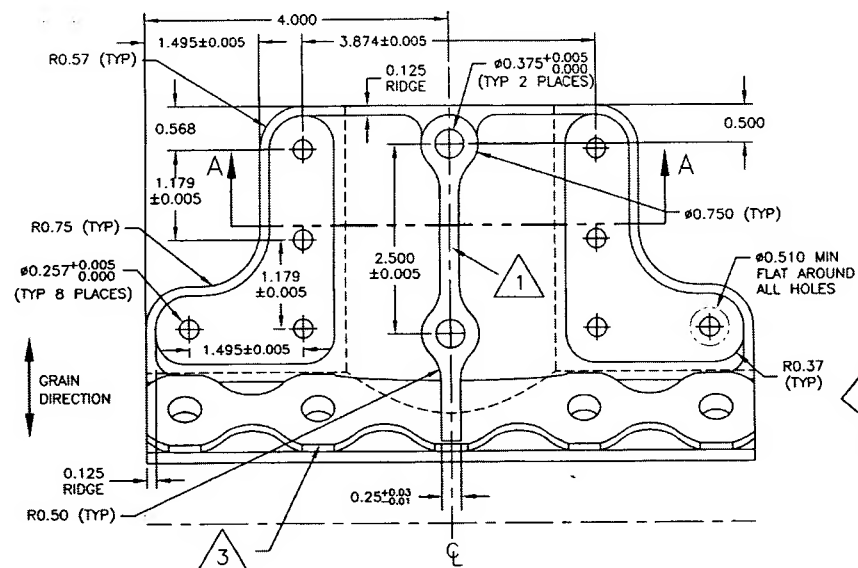
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	62	73	80	By	Date
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262	DT8683	.257	.257	.258	.258		
H	0.375	0.380	DT8684	.377	.377	.375	.375		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.180	1.180	1.179	1.180		
K	0.558	0.578		.571	.572	.572	.569		
L	1.174	1.184		1.180	1.180	1.179	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.875		
P	0.115	0.135		.123	.123	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.251		
S	0.115	0.135		.126	.125	.125	.126		
T	0.178	0.198		.184	.188	.184	.184		
U	2.940	2.980		2.967	2.967	2.963	2.961		
V	0.230	0.250		.238	.238	.240	.245		
W	0.115	0.135		.128	.128	.128	.128		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.360	.360		
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AE	1.375	1.395		1.387	1.386	1.386	1.380		
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AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.002	2.001	2.001	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JF
Date:	07/10/25

Audited by:	JF
Date:	07/10/26

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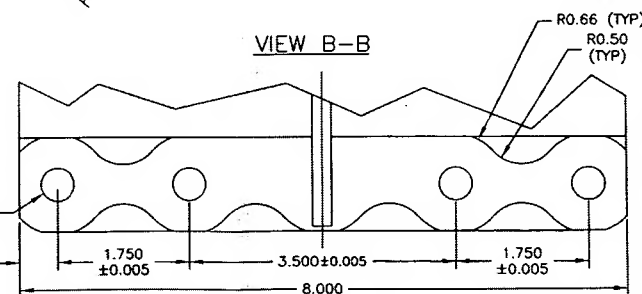
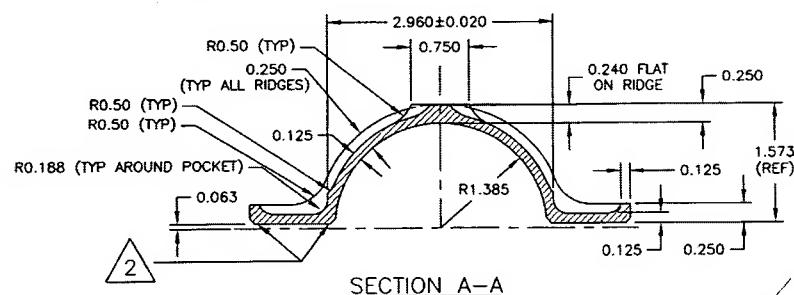
05.12.06



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E




DETAIL C  
SCALE 2:1

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34368

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DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
DS	DRAWN BY PH	
CHECKED	APPROVED	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE SCALE 2:1